

Date: Monday, 5/1/2006 4:22:45 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MOUNTING ANGLE
 Job Number : 26907
 Estimate Number : 10412
 P.O. Number : NIA Part Number : D2416
 This Issue : 5/1/2006 S.O. No. : NIA Drawing Number : D2416 REV. B
 Prsht Rev. : NC Project Number : N/A
 First Issue : NIA Type : MACHINED PARTS Drawing Revision : B
 Previous Run : NIA Material : NIA
 Due Date : 6/30/2006 Qty: 2 Um: Each
 Written By : See comment below
 Checked & Approved By : 06.05.02
 Comment : Est:C 03.04.14 Reformat; Incorporated D2292;
 D2375-3-08-106; D2403 - D2417 KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S063 2024-T3 .063 sheet



Comment: Qty.: 0.0255 sf(s)/Unit Total : 0.0510 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.063" thick

(M2024T3S.063)

Batch: 119059

Identify for D2416

SAD 06.05.24

(2)

2.0 SHEAR SHEAR



Comment: SHEAR

Cut blank: 2.050" x 1.550" Grain along 1.550"

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA327 and Dwg D2416

Stack of 7

Identify as D2416

water Jet

Dwg B
 Pros B

SAD 06.05.24

(2)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06.05.24

(2)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

En 06/05/25

2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 5/1/2006 4:22:45 PM
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Drawing Name: MOUNTING ANGLE

Job Number: 26907

Part Number: D2416

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr Stack

SN 06/05/25 x2

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE
Bend as per Dwg D2416

SB 06/06/01

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EN 06/06/02 x2

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

FC 06 06 02 (2)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

PU 06/06/05 (2)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST44

PU 06/06/05 (2)

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

PU 06/06/06 (2)



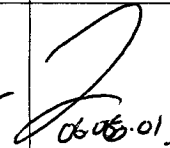
Job Completion



u 06/06/06




W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: ED Date: 06/26/07
 QA: N/C Closed: _____ Date: _____

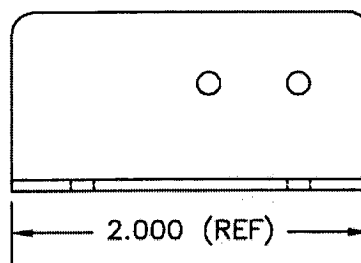
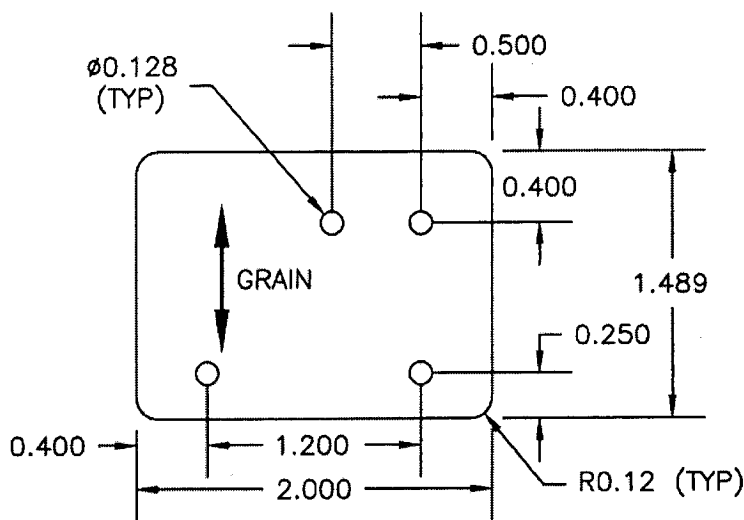
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
060601	7.0	Parts bent opposite to aug & parts scrap		Scrap: replace parts	SB 06/26/07	ED 06.06.02		 06.06.01

NOTE: Date & initial all entries



DESIGN BW		DRAWN BY 		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		DRAWING NO. D2416	
DATE 03.04.09		TITLE MOUNTING ANGLE		REV. B SHEET 1 OF 1	
A	95.04.06	NEW ISSUE			
B	03.04.09	ADDED Ø0.128 & FLAT PATTERN			

RELEASED
03.05.07



BEND DETAIL

1) MATERIAL: 2024-T3/T3511 0.063" THICK PER QQ-A-250/4 (REF DART SPEC: M2024-T3511-063) Y
2) FINISH: ACID ETCH AND ALODINE AS PER DART QSI 005 4.1
3) DEBURR ALL SHARP EDGES 0.005 TO 0.010
4) ALL DIMENSIONS ARE IN INCHES
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
PEC: M2024T3S063) Y
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 26907

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